

BAND SAW BLADES

SELECT THE RIGHT BAND SAW BLADE IN SIX STEPS

To get the best, most efficient performance from your band saw machine requires the proper band saw blade. The information below will give you the best blade recommendation in most cases.

There are always exceptions due to machine type/condition or some variation in the materials to be cut. **If you need help, we can assist you personally or by calling in a Starrett saw expert.**

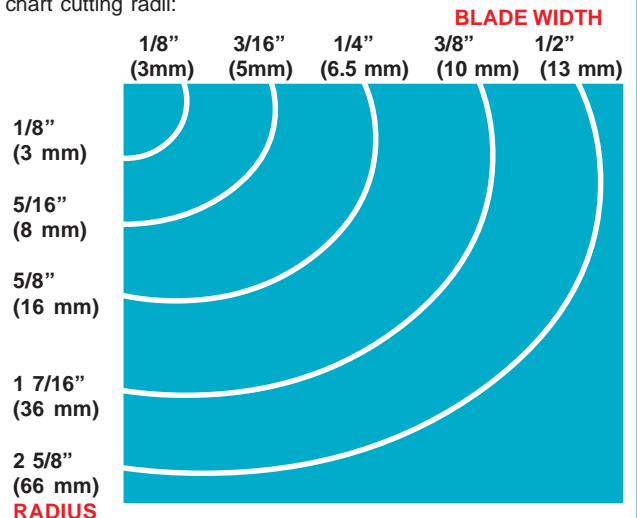
1 - BLADE TYPE

Use this chart to pick the blade that will work best for the materials to be cut, then refer to the blade-type page you have chosen for detailed information.

Materials	Starrett Blade Type
Exotic and Nickel-Based Alloys Such as Inconel and High-Hardness Steels in the Range of RC30-40	Best Powerband Pulsator® Good Powerband M-42 or Carbide Tipped
Tool Steel and Stainless Steel	Best Powerband M-42 Over 5" (125mm) Use Pulsator®
Alloy and High Carbon Steel	Best Powerband M-42
General Purpose	Best Powerband M-42
Carbon Steel	Best Powerband M-42 Good Premium Hardback or Flex-Back
Aluminum	Best Flex-Back Good Carbide Tipped
Cast Aluminum	Best Carbide Tipped Good Flex-Back
Thin Ferrous Sections	Best Friction Good Flex-Back
Composites, Fiberglass, Graphite, Ceramics, Etc.	Best Carbide Grit or Diamond Grit, If Carbide Can't Do It
Wood and Plastic	Best Flex-Back
Foam, Paper Products, Rubber, Etc.	Best Band Knives Good Flex-Back
Meat, Fish and Poultry	Best Meatkutter™

2 - BLADE WIDTH

Use the widest blade your machine will take except for contour cutting. Use this chart cutting radii:



3 - TOOTH RAKE

Straight (Zero), Positive, or Heavy Set*

RAKE SELECTION	Materials/Shapes To Be Cut
Positive	X X
Straight (Zero) and Heavy Set*	X X X X X X

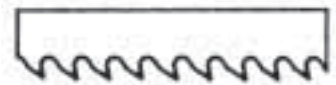
*Only available in Powerband M-42. Recommended for cutting heavy beams and bundles.

4 - TOOTH SHAPE:

Regular - A conventional tooth used for general purpose sawing, straight or zero rake.



Pulsator® - Positive rake, tapered teeth, used for aggressive production cutting of solids.



Hook - 10° positive rake for fast cutting of non-ferrous metals and non-metallics.



Skip - Straight rake and shallow gullets for cutting large sections of soft, non-ferrous material.



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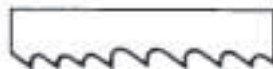
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5. - TYPE OF PITCH

Constant - All teeth on the blade have uniform spacing, gullet depth, rake angle throughout the full length. Usually general purpose cutting with Powerband Matrix II, Premium Hardback and Flex-Back types - identified by one pitch number.



Variable - Size of tooth and depth of gullet varies to substantially reduce noise levels and vibration so as to cut all structurals, tubing and solids, smoothly and quickly. Identified by two pitch numbers.



6. - PITCH

Pitch is generally regarded as the number of teeth per inch or 25 mm. Cutting thinner sections requires a finer pitch (more teeth per inch [25 mm]). Thick sections require coarser pitches (less teeth per inch/25 mm). The chart is a good guideline

Because the cross section limits in the chart are broad and overlap, choose a coarser pitch if the speed of cut is most important. Choose a finer pitch if finish is most important.

Constant Pitch Selection

Cross Section Thickness To Be Cut		Use constant Pitch
Inch	mm	
Up to 5/16"	Up to 8 mm	32 (Anything Thinner Than a 1/8" (3.2 mm) Cross Section Should Be Angled to the Blade)
5/32" - 1/2"	4-13 mm	24
7/32" - 5/8"	6-16 mm	18
1/4" - 7/8"	6.4-22 mm	14
3/8" - 1 1/4"	9.5-35 mm	10
1/2" - 1 1/2"	13-40 mm	8
1" - 2"	25-50 mm	6
1 1/2" - 3"	38-75 mm	4
2" - 4"	50-100 mm	3
3" - 6"	75-150 mm	2
4 1/2" - 9"	114-225 mm	1-1/4
8" and Over	200 mm and Over	3/4

Welding Service

Bands can be purchased pre-welded. Coil stock is also available for your in-house welding needs. Carbon product 1/4"-1" (6.3-25mm) and bi-metal 1/4"-1/2" (6.3-12.7mm) can be welded on standard welding equipment. Larger width blades should be welded on high speed type welders.

Variable Pitch Selection

Cross Section Thickness To Be Cut		Use Variable Pitch
Inch	mm	
7/32" - 7/8"	6-22 mm	14-18
1/4" - 1 1/4"	6.4-35 mm	10-14
11/32" - 1 1/2"	9-40 mm	8-12
3/8" - 2"	9.5-50 mm	6-10
1/2" - 2 3/8"	13-60 mm	5-8
1" - 3"	25-75 mm	4-6
1 1/2" - 4"	38-100 mm	3-4
2" - 6"	50-150 mm	2-3
3" - 12"	75-300 mm	1-2
8" and Over	200 mm and Over	3/4 - 1-1/4

Feeds and Speeds

The correct cutting feeds and speeds are important. Starrett furnishes a band saw blade selection slide chart for quick and easy reference as to the proper feeds and speeds to be used for the material being cut. The same information is also available on a PC disk.



Band Saw Blade Break-In Procedures

The proper break-in of a bi-metal blade assures longer blade life, faster cuts for a longer period of time and consistent performance.

Refer to the slide selection chart for proper feeds and speeds.

Easy-to-cut material such as carbon steel and aluminum - Run the normal surface feet per minute (SFM). Adjust the feed pressure to about one-half the normal cutting rate for the first few cuts or for 50-100 square inches (323-645 sq. cm). Increase to the normal cutting rate.

Hard -to-cut materials such as nickel-based alloys like Inconel, hardened steels, tool steels and stainless steels - Run the normal surface feet per minute (SFM). Adjust the feed pressure to about three-quarters of the normal cutting rate for the first two cuts or for 25-75 square inches (161-484 sq. cm), then increase the cutting rate part way to normal for the next few cuts, then increase to the normal cutting rate.

NOTE: Always make sure you are removing chips on these type of materials.

Starrett Trial Order Guarantee

Purchase any band saw blade recommended by Starrett, and we will guarantee that it will match or outperform your present blade, or your money back. Contact us for further details.



Starrett BAND SAW BLADES

SERIES 781:

POWERBAND M-42 (MATRIX II) COIL STOCK

Powerband M-42 is the ideal general purpose metal sawing blade.

Material: This bi-metal blade has a high speed steel cutting edge (contains 8 % cobalt) welded to an alloy steel back. This steel resists heat, abrasion and shock which allows faster cutting rates over a wide range of materials.

Versatility: Available in a wide range of thicknesses and widths. Can be used on horizontal machines and light-duty vertical machines equally well. The blade is the choice for **production cutting, contour cutting and general purpose cutting.**

Emperor™ Heavy Set: Also available in Heavy Set, 1-1/2" and 2" widths, for cutting wide flange beams and bundles. A proven performer on bundled structural steels, tubing, I and H beams, angle iron and other wide flange beams.

[Widths 1 1/2" (38 mm) through 2" (50 mm) available; please inquire.]

SPECIFICATIONS

Nominal Width x Thickness		Tooth Shape	Pitch & Rake*	EDP Order No. 100' (30m)	Price
Inch	mm				
1/4 x .025	6.5 x 0.65	Hook	6P	15833	
		Regular	10-14S	15835	
		Regular	14-18S	16092	
1/4 x .035	6.5 x 0.90	Hook	6P	15834	
		Regular	10S	13954	
		Regular	14S	13953	
		Regular	10-14S	15391	
		Regular	10-14S	15391	
3/8 x .025	10 x 0.65	Hook	4P	15836	
		Hook	6P	15838	
		Regular	8-12S	15840	
		Regular	10-14S	15841	
		Regular	14-18S	916093	
		Regular	14-18S	15394	
3/8 x .035	10 x 0.90	Hook	4P	15837	
		Hook	6P	15839	
		Regular	8S	13956	
		Regular	10S	13957	
		Regular	14S	13958	
		Regular	10-14S	15394	
1/2 x .020	13 x 0.50	Regular	10S	911410	
		Regular	14S	19437	
		Regular	18W	19438	
		Regular	24W	19439	
		Regular	10-14S	19440	
		Regular	14-18W	19441	
1/2 x .025	13 x 0.65	Hook	4P	15843	
		Hook	6P	15844	
		Regular	14S	19525	
		Regular	18W	15847	
		Regular	8-12S	15845	
		Regular	10-14S	15846	
1/2 x .035	13 x 0.90	Regular	14-18W	16094	
		Hook	3P	15842	
		Bearcat	4P	13148	
		Bearcat	6P	12528	
		Bearcat	6-10P	13269	
		Regular	6S	13959	
		Regular	8S	13960	
		Regular	10S	13961	
		Regular	14S	13962	
		Regular	8-12S	13980	
		Regular	10-14S	15395	



Nominal Blade Width x Thickness		Tooth Shape	Pitch & Rake*	EDP Order No. 150' (45m)	Price	EDP Order No. 250'(76m)	Price					
Inch	mm											
3/4 x .035	19 x 0.90	Hook	3P	15848		15849						
			6S	13963		13970						
		Regular	8S	13964		13971						
			10S	13965		13972						
			14S	14352		15850						
			4-6S	13088		13089						
			5-8S	13981		13987						
			6-10S	13090		13091						
			8-12S	13982		13988						
			10-14S	15402		15403						
			1" x .035"	25 x 0.90		Regular	6S	13966		13973		
8S	13967	13974										
10S	13968	13975										
2-3S	15789	15790										
3-4S	14933	14934										
4-6S	13027	13062										
5-8S	13983	13989										
6-10S	13028	13064										
8-12S	13984	13990										
10-14S	15415	15416										
Heavy Set												
Regular	5-8PH	21672			21673							
1-1/4" x .042"	32 x 1.10	Regular			2-3S		15791			16361		
					3-4S		14618			16363		
					4-6S		13029			16365		
					5-8S		13985			16367		
					6-10S	13030	16368					
			8-12S	16739	-							
		Regular	Heavy Set									
			2-3PH	21678	-							
			3-4PH	21676	21677							
			4-6PH	21674	21675							

***KEY:** P = Positive Rake W = Wavy Set (Zero) Rake
S = Straight (Zero) Rake H = Heavy Set

NOTE: 150' and 250' (45, 76 m) coils are shipped random lengths, which may vary plus or minus 10%.

See next page for
POPULAR SIZES
FACTORY WELDED TO LENGTH.
All other sizes available; please inquire



*KEY: P = Positive Rake W = Wavy Set, Zero Rake
 S = Straight (Zero) Rake SH = Heavy Set

• Popular Sizes Factory Welded to Length •

BI-METAL BAND SAW BLADES

POWERBAND M-42 SERIES 781:

Length	Width	Thick-ness	Tooth Shape	Pitch & Rake*	EDP Order No.	Price
5' 4-1/2	1/2	.020	Regular	10-14S	8115802	
5' 4-1/2	1/2	.020	Regular	14S	8116865	
5' 4-1/2	1/2	.020	Regular	24W	8116926	
5' 4-1/2	1/2	.025	Regular	10-14S	8116228	
5' 4-1/2	1/2	.025	Regular	14S	8114541	
5' 4-1/2	1/2	.025	Regular	14-18S	8116670	
5' 4-1/2	1/2	.025	Regular	18W	8116421	
5' 4-1/2	1/2	.035	Regular	10-14S	8115396	
7' 9	1/2	.035	Regular	14S	8114283	
7' 9	1/2	.025	Regular	14-18S	8116632	
7' 9	3/4	.035	Regular	5-8S	8119488	
7' 9	3/4	.035	Regular	6-10S	8116413	
7' 9	3/4	.035	Regular	8-12S	8116270	
7' 9	3/4	.035	Regular	10S	8116294	
7' 9	3/4	.035	Regular	10-14S	8116269	
7' 9	3/4	.035	Regular	14S	8116465	
9'	3/4	.035	Regular	5-8S	8114684	
9'	3/4	.035	Regular	6-10S	8113818	
9'	3/4	.035	Regular	8-12S	8116941	
9'	3/4	.035	Regular	10-14S	8115405	
9'6	3/4	.035	Regular	10-14S	8115406	
9'6	3/4	.035	Regular	14S	8117589	
10'	3/4	.035	Regular	5-8S	8119721	
10'	3/4	.035	Regular	6-10S	8119722	
10'	3/4	.035	Regular	8-12S	8119723	
10'5	3/4	.035	Regular	4-6S	8114546	
10'5	3/4	.035	Regular	5-8S	8116672	
10'5	3/4	.035	Regular	6-10S	8113664	
10'5	3/4	.035	Regular	8-12S	8115598	
10'5	3/4	.035	Regular	10S	8114305	
10'5	3/4	.035	Regular	10-14S	8115407	
10' 10-1/2	3/4	.035	Regular	4-6S	8115920	
10' 10-1/2	3/4	.035	Bearcat	4-6P	8113536	
10' 10-1/2	3/4	.035	Regular	5-8S	8114004	
10' 10-1/2	3/4	.035	Regular	6-10S	8113665	
10' 10-1/2	3/4	.035	Regular	8-12S	8114015	
10' 10-1/2	3/4	.035	Regular	10S	8114308	
10' 10-1/2	3/4	.035	Regular	10-14S	8115408	
10' 10-1/2	1"	.035	Regular	4-6S	8113683	
10' 10-1/2	1"	.035	Bearcat	4-6P	8114560	
10' 10-1/2	1"	.035	Regular	5-8S	8115094	
10' 10-1/2	1"	.035	Regular	6-10S	8113687	
10' 10-1/2	1"	.035	Regular	8-12S	8114548	
10' 10-1/2	1"	.035	Regular	10S	8114343	
10' 10-1/2	1"	.035	Regular	10-14S	8115417	
11'	3/4	.035	Regular	4-6S	8116671	
11'	3/4	.035	Regular	5-8S	8117587	
11'	1"	.035	Regular	4-6S	8116003	
11'	1"	.035	Bearcat	4-6P	8115517	
11'	1"	.035	Regular	5-8S	8115072	
11'	1"	.035	Regular	6-10S	8115520	
11'	1"	.035	Regular	8-12S	8115095	
11'	1"	.035	Regular	10-14S	8115884	
11'5	3/4	.035	Regular	5-8S	8114005	
11'5	3/4	.035	Regular	6-10S	8119489	
11'5	1"	.035	Regular	4-6S	8115760	
11'5	1"	.035	Regular	6-10S	8116404	
11'6	3/4	.035	Regular	4-6S	8113222	
11'6	3/4	.035	Bearcat	4-6P	8113537	
11'6	3/4	.035	Regular	5-8S	8114006	
11'6	3/4	.035	Regular	6-10S	8113666	
11'6	3/4	.035	Regular	8-12S	8114016	
11'6	3/4	.035	Regular	10S	8114310	
11'6	3/4	.035	Regular	10-14S	8115410	
11'6	3/4	.035	Regular	14S	8116674	
11'6	1"	.035	Regular	3-4S	8115757	
11'6	1"	.035	Bearcat	3-4P	8114732	

Length	Width	Thick-ness	Tooth Shape	Pitch & Rake*	EDP Order No.	Price
11' 6	1"	.035	Regular	4-6S	8113265	
11' 6	1"	.035	Bearcat	4-6P	8113541	
11' 6	1"	.035	Regular	5-8S	8114008	
11' 6	1"	.035	Regular	6-10S	8113255	
11' 6	1"	.035	Regular	8-12S	8114018	
11' 6	1"	.035	Regular	10-S	8114344	
11' 6	1"	.035	Regular	10-14S	8115418	
11' 6	1-1/4	.042	Regular	3-4S	8116127	
11' 6	1-1/4	.042	Regular	4-6S	8115905	
11' 6	1-1/4	.042	Regular	5-8S	8116943	
12'	1"	.035	Regular	3-4S	8115516	
12'	1"	.035	Bearcat	3-4P	8113367	
12'	1"	.035	Regular	4-6S	8113066	
12'	1"	.035	Bearcat	4-6P	8113543	
12'	1"	.035	Regular	5-8S	8114009	
12'	1"	.035	Regular	6-S	8114321	
12'	1"	.035	Regular	6-10S	8113108	
12'	1"	.035	Regular	8-12S	8114019	
12'	1"	.035	Regular	10-14S	8115419	
12'	1-1/4	.042	Regular	3-4S	8117050	
12'	1-1/4	.042	Bearcat	3-4P	8114805	
12'	1-1/4	.042	Regular	4-6S	8113266	
12'	1-1/4	.042	Regular	5-8S	8115490	
12' 6	1"	.035	Regular	3-4S	8116618	
12' 6	1"	.035	Regular	4-6S	8113684	
12' 6	1"	.035	Bearcat	4-6P	8117540	
12' 6	1"	.035	Regular	5-8S	8114010	
12' 6	1"	.035	Regular	6-10S	8113689	
12' 6	1"	.035	Regular	8-12S	8114020	
12' 6	1-1/4	.042	Regular	4-6S	8119740	
12' 6	1-1/4	.042	Regular	5-8S	8116123	
12' 6	1-1/4	.042	Regular	6-10s	8115907	
13' 3	1"	.035	Regular	3-4S	8116112	
13' 3	1"	.035	Regular	4-6S	8115993	
13' 3	1"	.035	Regular	5-8S	8116113	
13' 3	1"	.035	Regular	6-10S	8115883	
13' 3	1"	.035	Regular	8-12S	8116004	
13' 3	1"	.035	Regular	10-14S	8119495	
13' 6	1"	.035	Regular	3-4S	8115882	
13' 6	1"	.035	Bearcat	3-4P	8114800	
13' 6	1"	.035	Regular	4-6S	8113082	
13' 6	1"	.035	Bearcat	4-6P	8114562	
13' 6	1"	.035	Regular	5-8S	8114889	
13' 6	1"	.035	Regular	6-10S	8113691	
13' 6	1"	.035	Regular	8-12S	8115606	
13' 6	1"	.035	Regular	10-14S	8119496	
14' 6	3/4	.035	Bearcat	4-6P	8117543	
14' 6	3/4	.035	Regular	6-10S	8113819	
14' 6	3/4	.035	Regular	10-14S	8115412	
14' 6	1"	.035	Regular	3-4S	8115990	
14' 6	1"	.035	Bearcat	3-4P	8114559	
14' 6	1"	.035	Regular	4-6S	8113084	
14' 6	1"	.035	Bearcat	4-6P	8113547	
14' 6	1"	.035	Regular	5-8S	8114011	
14' 6	1"	.035	Regular	6-10S	8113693	
14' 6	1"	.035	Regular	8S	8114340	
14' 6	1"	.035	Regular	8-12S	8114021	
14' 6	1"	.035	Regular	10-14S	8115423	
15'	1-1/4	.042	Regular	3-4S	8115886	
15'	1-1/4	.042	Bearcat	3-4P	8113399	
15'	1-1/4	.042	Regular	4-6S	8113262	
15'	1-1/4	.042	Bearcat	4-6P	8113551	
15'	1-1/4	.042	Regular	5-8S	8114013	
15' 6	1"	.035	Regular	4-6S	8113085	
15' 6	1"	.035	Regular	5-8S	8116247	
15' 6	1-1/4	.042	Regular	3-4S	8115868	
15' 6	1-1/4	.042	Bearcat	3-4P	8113401	
15' 6	1-1/4	.042	Regular	4-6S	8113743	
15' 6	1-1/4	.042	Bearcat	4-6P	8113553	
15' 6	1-1/4	.042	Regular	5-8S	8114014	

SAW BLADES

Starrett COIL-STOCK SERIES 781:

GLADIATOR™ POWERBAND M-42

High performance bi-metal production band saw blades.

Features:

- New tooth design features triple-tempered M-42 high speed steel with 8% cobalt.

Benefits:

- Engineered for performance-measurable, production applications. Gladiator blades are versatile, cutting a broad range of steels, including mild and stainless steels, nickel-based and non-ferrous alloys in a variety of shapes.

Widths 1 1/2" (38 mm) through 3 1/8" (79 mm) available; please inquire. 250' (76 m) Coils available on most sizes, 3/4" (19 mm) and larger; please inquire.

Width x Thickness	Pitch & Rake*	EDP Order No. 150' Coil	Price	EDP Order No. 250' Coil	Price
3/4" .035" 19 x 0.90mm	4-6P	20563		20564	
	5-8P	20565		20566	
	6-10P	20567		20568	
1" x .035" 25 x 0.90mm	2-3P	20569		20570	
	3-4P	20571		20572	
	4-6P	20573		20574	
	5-8P	20575		20576	
	6-10P	20577		20578	
1-1/4" x .042" 32 x 1.10mm	1-2P	20579		-	
	2-3P	920580		920581	
	3-4P	20582		20583	
	4-6P	20584		20585	
	5-8P	20586		20587	
	6-10P	20588		-	

*KEY: P = Positive Rake
Tooth Shape=Gladiator

Welded Blades Available; Please Inquire.

GLADIATOR PULSATOR™ POWERBAND M-42

High performance bi-metal production band saw blades.

Features:

- New tooth design features triple-tempered M-42 high speed steel with 8% cobalt.

Benefits:

- Impressive performance on large, solid cross-sections of exotic and nickel-based alloys and other high hardness steels

Width x Thickness	Pitch & Rake*	EDP Order No. 150' Coil	Price	EDP Order No. 250' Coil	Price
1" x .035" 25 x 0.90mm	2-3P/T	920604		920605	
	3-4P/T	920606		920607	
	4-6P/T	920608		920609	
1-1/4" x .042" 32 x 1.10mm	2-3P/T	920616		-	
	3-4P/T	920610		-	
	4-6P/T	920611		-	

*KEY: P/T = Positive Rake
Tapered Tooth Shape = Gladiator up to 12° Positive Rake Angle

Welded Blades Available; please Inquire.

PREMIUM HARD-BACK

This high carbon steel band has precisely hardened teeth, coupled with a hard, tough spring tempered back, resulting in a high tensile strength. Greater band tension and improved blade rigidity increases cutting rates and provides more accurate cuts.

Applications: are light to medium vertical and horizontal machines, toolroom and maintenance, low alloy, non-ferrous metals.

Benefits:

- Economical production cutting
- Increased tensile strength
- More accurate and straighter cuts
- Improved blade rigidity for increased cutting rates.

For Welded Blades, see page 344

Nominal Width x Thickness		Tooth Shape	Pitch & Rake*	EDP Order No. 100' (30m)	Price		
Inch	mm						
1/4 x .025	6.5 x 0.65	Hook	4P	10995			
		Skip	4S	10985			
		Regular	6S	13892			
		Skip	6S	10986			
		Hook	6P	15821			
		Regular	10S	13893			
		Regular	14S	13894			
		Regular	18W	10941			
		Regular	24W	12910			
		Regular	32W	10971			
3/8 x .025	10 x 0.65	Hook	3P	10997			
		Skip	4S	10988			
		Hook	4P	10998			
		Hook	6P	15824			
		Regular	6S	13895			
		Regular	8S	13896			
		Regular	10S	13897			
		Regular	14S	13898			
		Regular	18W	10946			
		1/2 x .020	13 x 0.50	Regular	10S	10949	
Regular	14S			13900			
Regular	18W			10953			
Regular	24W			12913			
Skip	3S			10989			
1/2 x .025	13 x 0.65	-	-	-			
		Skip	4S	10990			
		Hook	4P	11002			
		Regular	6S	13899			
		Hook	6P	15827			
		Regular	10S	13322			
		Regular	10W	10972			
		Regular	14S	13901			
		Regular	14W	13902			
		Regular	18W	10954			
		Regular	24W	10975			
		5/8 x .032	16 x 0.80	Regular	10S	13328	
				Regular	14S	13903	
3/4 x .032	19 x 0.80	Hook	3P	13905			
		Hook	4P	15830			
		Regular	6S	13906			
		-	-	-			
		Regular	8S	13331			
		Regular	10S	10963			
		Regular	10W	10979			
		Regular	14S	13907			
		Regular	14W	13908			
		Regular	18W	10982			
1 x .035	25 x 0.90	Hook	3P	13909			
		Regular	6S	13910			
		Regular	8S	13337			
		Regular	10S	13340			
		Regular	14S	13911			

*KEY: P = Positive Rake
S = Straight (Zero) Rake
W = Wavy Set, Zero Rake
250' (76m) and 500' (152m) coils available; please inquire.

Starrett BAND SAW BLADES

PREMIUM HARD-BACK

SERIES 781:



• Popular Sizes Factory Welded to Length •

Length	Width	Thick-ness	Tooth Shape	Pitch & Rake*	EDP Order No.	Price
5'	1/2	.025	Regular	10S	8111165	
5'	1/2	.025	Regular	14S	8114163	
5'	1/2	.025	Regular	18W	8111169	
5' 4	1/2	.025	Regular	10S	8115084	
5' 4	1/2	.025	Regular	14S	8114164	
5' 4	1/2	.025	Regular	18W	8114380	
5' 4-1/2	1/2	.025	Regular	6S	8115879	
5' 4-1/2	1/2	.025	Regular	10S	8112677	
5' 4-1/2	1/2	.025	Regular	14S	8114165	
5' 4-1/2	1/2	.025	Regular	18S	8112816	
5' 4-1/2	1/2	.025	Regular	24S	8112706	
7' 5	1/2	.025	Regular	6S	8114154	
7' 5	1/2	.025	Regular	10S	8111175	
7' 5	1/2	.025	Regular	14S	8114169	
7' 5	1/2	.025	Regular	18W	8111179	
7' 9	1/4	.025	Regular	6S	8114125	
7' 9	1/4	.025	Regular	10S	8114372	
7' 9	1/4	.025	Regular	14S	8114135	
7' 9	1/2	.025	Skip	4S	8111193	
7' 9	1/2	.025	Regular	6S	8114155	
7' 9	1/2	.025	Regular	10S	8111195	
7' 9	1/2	.025	Regular	14S	8114173	
7' 9	1/2	.025	Regular	18W	8111199	
7' 9	1/2	.025	Regular	24W	9111200	
7' 9	3/4	.032	Regular	8S	8116718	
7' 9	3/4	.032	Regular	10S	8115927	
7' 9	3/4	.032	Regular	14S	8115613	
7' 9	3/4	.032	Regular	18W	8116711	
7' 9 -1/2	1/2	.025	Hook	4S	8112736	
7' 9 -1/2	1/2	.025	Skip	4S	8111213	
7' 9 -1/2	1/2	.025	Regular	6S	8114156	
7' 9 -1/2	1/2	.025	Regular	10S	8111215	
7' 9 -1/2	1/2	.025	Regular	14S	8114174	
7' 9 -1/2	1/2	.025	Regular	18W	8111218	
7' 9 -1/2	1/2	.025	Regular	24W	8111220	
8'	1/2	.025	Regular	6S	8114158	
8'	1/2	.025	Regular	10S	8111224	
8'	1/2	.025	Regular	14S	8114177	
8'	1/2	.025	Regular	18W	8114780	
8' 2-1/2	5/8	.032	Regular	10S	8110548	
8' 2-1/2	5/8	.032	Regular	14S	8114090	

Length	Width	Thick-ness	Tooth Shape	Pitch & Rake*	EDP Order No.	Price
8' 5	3/4	.032	Regular	6S	8116300	
8' 5	3/4	.032	Regular	10S	8113628	
8' 5	3/4	.032	Regular	14S	8114226	
8' 11	5/8	.032	Regular	14S	8114213	
8' 11	3/4	.032	Regular	10S	8112329	
8' 11	3/4	.032	Regular	14S	8114228	
9'	3/4	.032	Regular	6S	8114784	
9'	3/4	.032	Regular	8S	8113808	
9'	3/4	.032	Regular	10S	8111253	
9'	3/4	.032	Regular	14S	8114227	
9' 6	3/4	.032	Regular	10S	8114533	
9' 6	3/4	.032	Regular	14S	8114534	
10' 5	3/4	.032	Regular	6S	8114219	
10' 5	3/4	.032	Regular	8S	8111272	
10' 5	3/4	.032	Regular	10S	8111274	
10' 5	3/4	.032	Regular	14S	8114233	
10' 5	3/4	.032	Regular	18W	8111280	
10' 10-1/2	3/4	.032	Regular	6S	8114220	
10' 10-1/2	3/4	.032	Regular	8S	8111287	
10' 10-1/2	3/4	.032	Regular	10S	8111289	
10' 10-1/2	3/4	.032	Regular	14S	8114235	
11' 5	3/4	.032	Regular	10S	8111304	
11' 5	3/4	.032	Regular	14S	8114237	
11' 5	1"	.035	Regular	8S	8115041	
11' 5	1"	.035	Regular	10S	8112818	
11' 6	3/4	.032	Regular	6S	8114221	
11' 6	3/4	.032	Regular	8S	8111321	
11' 6	3/4	.032	Regular	10S	8111323	
11' 6	3/4	.032	Regular	14S	8114239	
11' 6	3/4	.032	Regular	18W	8111329	
11' 6	1"	.035	Regular	6S	8114258	
11' 6	1"	.035	Regular	8S	8111331	
11' 6	1"	.035	Regular	10S	8111332	
11' 6	1"	.035	Regular	14S	8114266	
11' 6	1"	.035	Regular	6S	8114723	
12'	1"	.035	Regular	8S	8112713	
12'	1"	.035	Regular	10S	8111357	
12'	1"	.035	Regular	14S	8114268	
12' 6	1/2	.025	Hook	4S	8115083	
12' 6	1/2	.025	Skip	4S	8113105	
12' 6	1/2	.025	Hook/HP	6S	8116663	
12' 6	1/2	.025	Regular	6S	8114160	
12' 6	1/2	.025	Regular	10S	8111365	
12' 6	1/2	.025	Regular	14S	8114188	
12' 6	1/2	.025	Regular	18W	8114781	
12' 6	3/4	.032	Regular	10S	8112687	
12' 6	3/4	.032	Regular	14S	8114241	
12' 6	1"	.035	Regular	6S	8114260	
12' 6	1"	.035	Regular	8S	8115511	
12' 6	1"	.035	Regular	10S	8112978	
12' 6	1"	.035	Regular	14S	8114539	



While we show only the most popular **STARRETT® SAW BLADES** we can supply their entire range of products; please inquire.

* KEY:

P = Positive Rake

S = Straight (Zero) Rake

W = Wavy Set, Zero Rake

Starrett BAND SAW BLADES
CARBON FLEX-BACK COIL-STOCK
SERIES 781:

Wood and Metal Cutting - Flex-Back, made from carbon steel with a flexible back, is recommended for general purpose cutting at an attractive cost on easy-to-machine ferrous metal. It has an excellent fatigue factor to give long life on machines running at a high Surface Feet Per Minute (SFM), cutting non-ferrous metal and wood (not recommended above 10,000 SFM [3,000 m]). Its flexible feature is also suitable for absorbing contour cutting stresses.

Benefits:

- Economical general purpose cutting
- Can be welded on standard welding equipment
- The greatest variety of widths, thicknesses and tooth shapes to suit any purpose
- Ideal for both contour and straight cutting

Applications :

- Light to medium, vertical and horizontal machines
- Low alloy, non-ferrous metal
- Furniture, composition board
- Plastics of numerous types
- Non-ferrous foundry materials



Nominal Width x Thickness		Tooth Shape	Pitch & Rake**	EDP Order No. 100' (30m)	Price
Inch	mm				
1/16 x .025	1.6 x 0.65	Regular	24S	10001	
1/8 x .025	3 x 0.65	Regular	14S	10004	
		Regular	18S	10005	
3/16 x .014	4.8 x 0.35	Regular	8S	15007	
		Regular	14S	15008	
3/16 x .025	4.8 x 0.65	Skip	4S	10073	
		Regular	10S	10007	
		Regular	14S	10008	
		Regular	18W	10009	
1/4 x .014	6.5 x 0.35	Skip	6S	15009	
		Regular	14S	15011	
1/4 x .025	6.5 x 0.65	Hook	4P	10098	
		Skip	4S	10074	
		Skip	6S	10076	
		Hook	6P	15803	
		Regular	6S	13828	
		Regular	10S	13829	
		Regular	14S	13830	
		Regular	18W	10015	
Regular	24W	12898			
Regular	32W	10055			
1/4 x .032	6.5 x 0.80	Hook*	4P	12594	
		Hook*	4S	12626	
3/8 x .014	10 x 0.35	Skip	6S	15013	
		Regular	14S	15014	
3/8 x .025	10 x 0.65	Skip	3S	10077	
		Hook*	3P	10100	
		Skip	4S	10079	
		Hook	4P	10101	
		Hook	6P	15806	
		Regular	6S	13831	
		Regular	8S	13832	
		Regular	10S	13833	
		Regular	14S	13834	
		Regular	18W	10020	
Regular	24W	12904			
3/8 x .032	10 x 0.80	Hook*	3P	9912595	
		Skip	3S	12596	
		Hook*	4P	9912597	
		Skip	4S	9912598	
1/2 x .020	13 x 0.50	Regular	10S	10024	
		Regular	14S	13836	
		Regular	18W	10028	
		Regular	24W	10057	

Nominal Width x Thickness		Tooth Shape	Pitch & Rake**	EDP Order No. 100' (30m)	Price
Inch	mm				
1/2 x .025	13 x 0.65	Skip	3S	10083	
		Hook	3P Low Profile	10104	
		Hook*	3P High Profile	14477	
		Skip	4S	10085	
		Hook	4P	10105	
		Hook	6P	15809	
		Regular	6S	13835	
		Regular	10S	10025	
		Regular	10W	10058	
		Regular	14S	13837	
		Regular	14W	13838	
		Regular	18W	10029	
Regular	24W	10061			
1/2 x .032	13 x 0.80	Hook*	3P	12599	
		Hook*	4P	12601	
		Skip*	4S	12602	
5/8 x .032	16 x 0.80	Regular	10S	10033	
		Regular	14S	13839	
3/4 x .032	19 x 0.80	Skip	3S	10089	
		Hook	3P	14029	
		Hook	4P	15815	
		Regular	6S	13840	
		Hook	6P	15812	
		Regular	8S	10037	
		Regular	10S	10038	
Regular	10W	10065			
Regular	14S	13841			
1 x .035	25 x 0.90	Hook	2P	10112	
		Hook	3P	13843	
		Skip	3S	10094	
		Regular	6S	13844	
		Regular	8S	10044	
		Regular	10S	10045	
1 1/4 x .042	32 x 1.10	Bearcat*	1-1/4P	15859	

*Especially good on wood.

NOTE:

Coils are shipped random length, which may vary plus or minus 10%.

**** KEY:**

- P** = Positive Rake
- S** = Straight (Zero) Rake
- W** = Wavy Set, Zero Rake

250' (76m) and 500' (152m) coils available; please inquire.

**FLEX-BACK CARBON
SERIES 781:**

• Popular Sizes Factory Welded to Length •



SAW BLADES

Length	Width	Thick-ness	Tooth Shape	Pitch & Rake*	EDP Order No.	Price
5'	1/2	.025	Regular	10S	8110352	
5'	1/2	.025	Regular	14S	8114062	
5'	1/2	.025	Regular	18W	8110357	
5' 4	1/2	.025	Regular	10S	8114402	
5' 4	1/2	.025	Regular	14S	8114437	
5' 4	1/2	.025	Regular	18W	8115458	
5' 4-1/2	1/2	.025	Regular	6S	8115050	
5' 4-1/2	1/2	.025	Regular	10S	8112351	
5' 4-1/2	1/2	.025	Regular	14S	8114063	
5' 4-1/2	1/2	.025	Regular	18W	8110365	
5' 4-1/2	1/2	.025	Regular	24W	8114642	
7' 5	1/2	.025	Regular	6S	8115593	
7' 5	1/2	.025	Regular	10S	8110402	
7' 5	1/2	.025	Regular	14S	8114067	
7' 5	1/2	.025	Regular	18W	8110406	
7' 9	1/4	.025	Regular	10S	8114032	
7' 9	1/4	.025	Regular	14S	8114037	
7' 9	1/4	.025	Regular	18W	8110444	
7' 9	1/2	.025	Skip	4S	8110454	
7' 9	1/2	.025	Regular	6S	8114053	
7' 9	1/2	.025	Regular	10S	8110457	
7' 9	1/2	.025	Regular	14S	8114069	
7' 9	1/2	.025	Regular	18W	8110461	
7' 9	1/2	.025	Regular	24W	8114064	
7' 9	3/4	.032	Regular	6S	8116442	
7' 9	3/4	.032	Regular	8S	8116651	
7' 9	3/4	.032	Regular	10S	8115926	
7' 9	3/4	.032	Regular	14S	8116419	
7' 9 -1/2	1/2	.025	Skip	4S	8110489	
7' 9 -1/2	1/2	.025	Regular	6S	8114054	
7' 9 -1/2	1/2	.025	Regular	10S	8110492	
7' 9 -1/2	1/2	.025	Regular	14S	8114070	
7' 9 -1/2	1/2	.025	Regular	18W	8110496	
7' 9 -1/2	1/2	.025	Regular	24W	8110499	
8'	1/2	.025	Regular	10S	8110518	
8'	1/2	.025	Regular	14S	8114073	
8' 2-1/2	5/8	.032	Regular	10S	8110548	
8' 2-1/2	5/8	.032	Regular	14S	8114090	
8' 5	3/4	.032	Regular	10S	8115610	
8' 5	3/4	.032	Regular	14S	8114644	

Length	Width	Thick-ness	Tooth Shape	Pitch & Rake*	EDP Order No.	Price
8' 11	5/8	.032	Regular	14S	8114092	
8' 11	3/4	.032	Regular	6S	8115727	
8' 11	3/4	.032	Regular	8S	8115728	
8' 11	3/4	.032	Regular	10S	8112930	
8' 11	3/4	.032	Regular	14S	8114101	
9'	3/4	.032	Regular	6S	8114755	
9'	3/4	.032	Regular	8S	8115504	
9'	3/4	.032	Regular	10S	8110585	
9'	3/4	.032	Regular	14S	8114440	
9' 6	3/4	.032	Regular	6S	8116716	
9' 6	3/4	.032	Regular	8S	8115875	
9' 6	3/4	.032	Regular	10S	8115118	
9' 6	3/4	.032	Regular	14S	8115545	
10' 5	3/4	.032	Regular	6S	8114094	
10' 5	3/4	.032	Regular	8S	8110658	
10' 5	3/4	.032	Regular	10S	8110660	
10' 5	3/4	.032	Regular	14S	8114102	
10' 10-1/2	3/4	.032	Regular	6S	8114095	
10' 10-1/2	3/4	.032	Regular	8S	8110674	
10' 10-1/2	3/4	.032	Regular	10S	8110676	
10' 10-1/2	3/4	.032	Regular	14S	8114103	
11' 5	3/4	.032	Regular	10S	8110693	
11' 5	3/4	.032	Regular	14S	8114104	
11' 5	1"	.035	Regular	10S	8112378	
11' 6	3/4	.032	Regular	6S	8114096	
11' 6	3/4	.032	Regular	8S	8110715	
11' 6	3/4	.032	Regular	10S	8110717	
11' 6	3/4	.032	Regular	14S	8114105	
11' 6	1"	.035	Regular	6S	8114114	
11' 6	1"	.035	Regular	8S	8110725	
11' 6	1"	.035	Regular	10S	8110726	
11' 6	1"	.035	Regular	14S	8114119	
12'	1"	.035	Regular	6S	8114115	
12'	1"	.035	Regular	10S	8110777	
12' 6	1/2	.025	Hook	4S	8116393	
12' 6	1/2	.025	Skip	4S	8110796	
12' 6	1/2	.025	Hook/	6S	8116397	
12' 6	1/2	.025	HP	6S	8114056	
12' 6	1/2	.025	Regular	10S	8110798	
12' 6	1/2	.025	Regular	14S	8114078	
12' 6	1/2	.025	Regular	18W	8112780	
12' 6	3/4	.032	Regular	10S	8115120	
12' 6	1"	.035	Regular	6S	8114116	
12' 6	1"	.035	Regular	8S	8116117	
12' 6	1"	.035	Regular	10S	8115751	
12' 6	1"	.035	Regular	14S	8114120	

* KEY: P = Positive Rake
S = Straight (Zero) Rake
W = Wavy Set, Zero Rake



While we show only the most popular **STARRETT® SAW BLADES** we can supply their entire range of products; please inquire.

Starrett BAND SAW BLADES

BLADES FOR PORTABLE BAND SAW MACHINES

SERIES 781:

Two Starrett blade types are offered to improve the usage of these handy power tools.

Bi-Metal Unique™ The best all-around bi-metal blade available. Cuts harder materials faster and longer.

Flex-Back: These blades combine good, general purpose cutting with low cost - a good value.



Blades are supplied welded in convenient lengths, ready to go to work. **Packaged three per cardboard sleeve.** Also available in 100' and 250' (30 and 76m) coils on previous pages.

Welded Ready-To-Use Specifications

Fits Machine Models	Length			Width x Thickness	Pitch & Rake*	Blade Type					
						Flex-Back			Powerband M-42		
	Feet	Inches	cm	Inch/mm	Cat. No.	Order No.	Price	Cat. No.	Order No.	Price	
Black & Decker, Greenlee, Milwaukee, Rockwell, Ridgid, Porter-Cable, Skil, Unitec	3' 8-7/8"	44 7/8"	114 cm	1/2" x .020" 13 x 0.50mm	10S	HE10	10338		BM10	14600	
					14S	HE14	10340		BM14	14601	
					18W	HE18	10341		BM18	14602	
					24W	HE24	10343		BM24	14603	
					10-14S				BM1014	15708	
Greenlee, Rockwell, Porter-Cable	4' 5-3/4"	53 3/4"	136.5cm	1/2 x .020" 13 x 0.50mm	14-18S				BM1418	16088	
					10S				RBM10	14604	
					14S				RBM14	14605	
					18W				RBM18	14606	
					24W				RBM24	14607	
Ensley, Greenlee, Porter-Cable Millers Falls	4' 6"	54"	137cm	1/2" x .025" 13 x 0.65mm	10-14S				RBM1014	15709	
					14-18S				RBM1418	16089	
					18W				GBM18	16635	
					8-12S				GBM812	16636	
					10-14S				GBN1014	16637	
14-18S				GBM1418	16638						

*KEY: S = Straight (Zero) Rake W = Wavy Set, (Zero) Rake

Starrett

SPECIAL PURPOSE BAND SAW BLADES

SERIES 781: (Please inquire for details.)

MEATKUTTER™ BLADE



For meat, fish and poultry band saw machines, these blades are .020" (0.50 mm) thick, so they produce minimal meat loss.

- Meatkutter blades are made of clean-cut stainless steel. These blades offer high levels of hygiene to the food industries when cutting meat, fish and poultry. The stainless steel blade can be washed down without risk of rusting, thereby avoiding hygiene problems.

- Tooth shape is skip

Other Types of Starrett Band Saws Available; please inquire.

POWERBAND PULSATOR®



Pulsator is a high performance bi-metal band saw blade with a uniquely designed tooth edge that allows the teeth to cut in a fast "pulsating" action. Pulsator is ideal for the production cutting of solids such as exotic and nickel-based alloys and high hardness steels.

Features:

- Unique tooth design and blade set
- M-42 high-speed edge contains 8% cobalt
- Tooth hardness RC67-69
- Patented

Benefits:

- Faster, enhanced cutting action vs. regular M-42
- Greater wear and heat resistance
- Avoids machine damage
- Cuts through the work hardened zone
- Longer blade life, more efficiency

(Continued)

SERIES 781:

(Please inquire for details.)

(Continued)

BAND KNIVES

Razor-edge band knives are available with either a single or double edge bevel in straight, scallop, wavy or V-tooth cutting edges. These variations enable them to cut foam, paper, rubber, soft plastic and other fibrous material quickly, smoothly and without waste because their slicing action produces no chips.



CARBIDE GRIT BANDS

These band saw blades will easily cut through most hard and abrasive materials. Starrett carbide band saw blades are especially useful in cutting new and complex materials such as composite graphite, fiber-reinforced plastics and titanium. In some cases, they cut better than regular blades. In other cases, they're the only blades that will cut when a regular band can't.



DIAMOND GRIT BANDS

If your material cannot be cut satisfactorily with carbide grit bands, then we recommend diamond grit bands. Typical materials that can be cut with these blades are glass-fired ceramics, stone, silicon, Pyrex, laminated fiberglass, etc.



FRICTION CUTTING BLADES

Made of a special fatigue resistant material, this blade is ideal for thin, ferrous sections. It is made of a high-silicon alloy and has a fully hardened tooth with a special tempered back allowing it to be run at speeds up to the 15,000 SFM (4500 m) necessary to achieve the melting point of the ferrous metal to be friction cut. A heavy tooth set further enhances the fast cutting action of these blades. Teeth with "air scoop" action brings oxygen into the kerf to burn up the metal. Cuts materials up to 5/8" (16 mm) thick.



CARBIDE TIPPED BAND SAW BLADES

If our regular band saw blades won't cut it, these blades will.

Type I

A unique carbide cylinder, selected for its toughness, shock and wear resistance, is welded to a tough, ductile back. Together, this results in a carbide tipped blade that allows faster, smoother cutting at a lower cost on a variety of materials.

Applications - Aluminum castings, fiberglass, masonite, plastics, composite materials and abrasive wood.



Type III

A unique carbide cylinder, selected for its extreme resistance to wear and heat. High hardness teeth are welded to a tough ductile back. Together, this results in a carbide tipped band saw that allows faster and smoother cutting at a lower cost on the very difficult to machine metals.

Applications - Difficult to machine steels, high-alloy metals, titanium, stainless steel, inconel, etc.

POWERBAND M-42 VARIHOOK

Powerband Varihook has variable-pitch, positive rake teeth with a constant gullet depth for greater beam strength and longer life.

Features:

- M-42 high-speed edge contains 8% cobalt
- Tooth hardness RC67-69
- Unique pitch shape and pattern

Benefits:

- Rugged bi-metal band for heavy-duty cutting jobs
- Longer life and blade efficiency



Coated Abrasive Terminology Key

GRADING	GRIT SIZE	BACKING	CLOTH TYPE	BACKING FLEXIBILITY	MINERAL (ABRASIVE)	BACKING	BOND	PERFORMANCE	COATING
P FEPA ANSI	12	PAPER:	B POLY COTTON BLEND	F FLEXIBLE	(0) CORK	0 MESH	0 GLUE	A ANTI-STATIC	O OPEN COAT
		A		STANDARD	(1) CROCLUS	1 PAPER	1 LUG	D DRI-LUBE OVERSIZE	CLOSED COAT
		B			(2) EMERY	2 COMB.	2 LU	R REACTIVE OVERSIZE	
		C	C COTTON	S STIFF	(3) GARNET	3 FILM	3 RG OR LI	W WASHABLE OR WATERPROOF	
		D			(4) S/C (SILICON CARBIDE)	4 FIBRE			
		E	G GLASS		(5) WA (WHITE A/O)	CLOTH:	FULL RESIN:		
		F			(6) PA (PINK A/O)	5 MOST FLEXIBLE	4 LEAST DURABLE		
			N POLY NYLON		(7) LBA (LIGHT BROWN A/O)				
					(8) A/O (ALUMINUM OXIDE)				
			P POLY- ESTER		(9) HT A/O (HEAT-TREATED)				
					(10) OPEN				
			R RAYON		(11) ZA (ZIRCONIA ALUMINA)	9 LEAST FLEXIBLE	9 MOST DURABLE		
					(12) ZA (PREMIUM)				
					(13) SG (REDUCED RATIO)				
					(14) SG (CERAMIC ALUMINA)				
					(15) SG (FULL RATIO)				
					(16) S/C-CORK SUPER FINISHING				
					(17) A/O-CORK SUPER FINISHING				